



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4151-1
Job Sheet 169299



Part No: D4151-1

Job Qty: 40 ea

Part Name: Lower Hardpoint Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/6/17

Job Tracking No:

Due Date: 12/19/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C SHEET 2 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	12/18/17	12/18/17	0.00	0.00	Start Up Waterjet		
100	Waterjet	40 pcs	12/19/17	12/19/17	0.00	1.53	Waterjet1		DAS
120	QC	40 pcs	12/19/17	12/19/17	0.00	0.00	QC8		38
150	Packaging	40 pcs	12/19/17	12/19/17	0.00	0.00	Packaging3		SMP
160	QC21-SA	40 Ea	12/19/17	12/19/17	0.00	0.00	QC21		DAS

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	2	100	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Hardpoint Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Lower Hardpoint Plate	0.252Inches + 0.003 - 0.000	0.255 0.252	Diameter	
3	Lower Hardpoint Plate	0.375Inches ± 0.010	0.385 0.365		
4	Lower Hardpoint Plate	3.128Inches ± 0.010	3.138 3.118		
5	Lower Hardpoint Plate	1.000Inches ± 0.010	1.010 0.990		
6	Lower Hardpoint Plate	0.500Inches ± 0.030	0.530 0.470		
7	Lower Hardpoint Plate	3.660Inches ± 0.030	3.690 3.630		
8	Lower Hardpoint Plate	2.000Inches ± 0.030	2.030 1.970		
9	Lower Hardpoint Plate	1.000Inches ± 0.003	1.003 0.997		
10	Lower Hardpoint Plate	0.125Inches ± 0.010	0.135 0.115		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST _____	
Part No. _____		Rework ☐		Jet ☐	
NCR No. _____		Scrap ☐		or. ☐	
Date: _____		Use-as-is ☐		ng ☐	
Step #: _____		Suspected Unapproved ☐		er ☐	
Description Work Order Deviation		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Engineering ☐	
				Quality ☐	
				Other ☐	
				MRB (QSI042) Approval	
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		Pressure/Forced		Positioned Wrong	
Environment ☐	No Re-verification ☐	Bending ☐	Centre Not Concentric ☐	Outside Dimensions ☐	
Design ☐	Operator ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Over/Under tolerance ☐	
Doc/Data ☐	Supplier ☐	Cuffs ☐	Crushing ☐	Part Incorrect ☐	
Equip/Tooling ☐	Training ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Part Lost/Missing ☐	
Handling/Pre ☐	Use for Testing ☐	Marks/Chatter ☐	Drill Holes ☐	Part Moved ☐	
Material ☐	Poor Information ☐	OTHER: _____		Drawing ☐	
Internal Transport ☐	Rushing ☐			Finish ☐	
Tribal Knowledge ☐	Product Improvement ☐			Misread ☐	
LOA ☐	Process Improvement ☐			Turning Sequence ☐	
Substation ☐	Manufacturing Process ☐				
Past Expiry Date ☐	Past Due ☐				
Misidentified ☐					

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D4151-1

Start up Operation

Mfg Date: 12/12/17

Job No: 169299

PART NO:

Revision:

Operation:

Change No:

misfunction

Misaligned/off center

